ASAP

Work Order ID 77575

77575

March-08-12 12:42:00 PM

Item ID: D3531-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Bracket Front Plate

Start Date: 12/13/11 **Start Qty:** 6.00 *6*
Required Date: 1/05/12 **Req'd Qty:** 6.00 *6*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** U **Date:** **Tooling:** **Date:** **Run Start** *NR1*
QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3531	Rev A								
100	FLOW WATER JET	0.00							
100									
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3531 Dwg Rev: A Prog Rev: A 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	**Memo**	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	**Memo**	0.00							
Quality Control									

B 12-3-8

6

5/10/09

46

B 12-3-8

Work Order ID 77575

March-08-12 12:42:00 PM

77575

Item ID: D3531-3
Revision ID:
Item Name: Bracket Front Plate

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Start Date: 12/13/11 **Start Qty:** 6.00 *6*
Required Date: 1/05/12 **Req'd Qty:** 6.00 *6*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab **Memo** Deburr if necessary.	0.00 0.00 N/A							
140 *140* Brake NC Brake NC	NC BRAKE **Memo** Bend as per Dwg D3530	0.00 0.00 SB 12/03/10				6			
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00 SJ 12/3/10				6			

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Revision ID: **Stop** *NS2*

Item Name: Bracket Front Plate

Start Date: 12/13/11 **Start Qty:** 6.00 *6*

Required Date: 1/05/12 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160 HandFinish Hand Finishing	**Memo**	0.00							
170	QC3- Inspect Part Finish	0.00							
170 QC Quality Control	**Memo**	0.00							
180	Identify as per dwg & Stock Location	0.00							
180 Packaging Packaging	**Memo**	0.00							

6X ∅ MA 12/03/09

6x ∅ MA 12/03/09

(6x) SP 12-03-12.

Work Order ID 77575

March-08-12 12:42:00 PM

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Item ID: D3531-3
Revision ID:
Item Name: Bracket Front Plate

Start Date: 12/13/11 **Start Qty:** 6.00 *6*
Required Date: 1/05/12 **Req'd Qty:** 6.00 *6*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	**Memo**	0.00							
Quality Control									

12/3/12
MF
12-03-12

Picklist Print

March-08-12 12:41:59 PM

Work Order ID: 77575

Parent Item: D3531-3

Parent Item Name: Bracket Front Plate

Start Date: 12/13/11 **Required Date:** 1/05/12

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP Rev:A New Issue 07-09-24 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	184.3670	**0.1313**	**0.8292632**			

B12-3-8

(6)

Location	Loc Qty	Loc Code	
MAT021	184.367		
117653	27.91		
120218	156.457		(20)(8)

DART AEROSPACE LTD	Work Order:	17575
Description: Bracket Front Plate	Part Number:	D3531-3
Inspection Dwg: D3531 **Rev:** A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

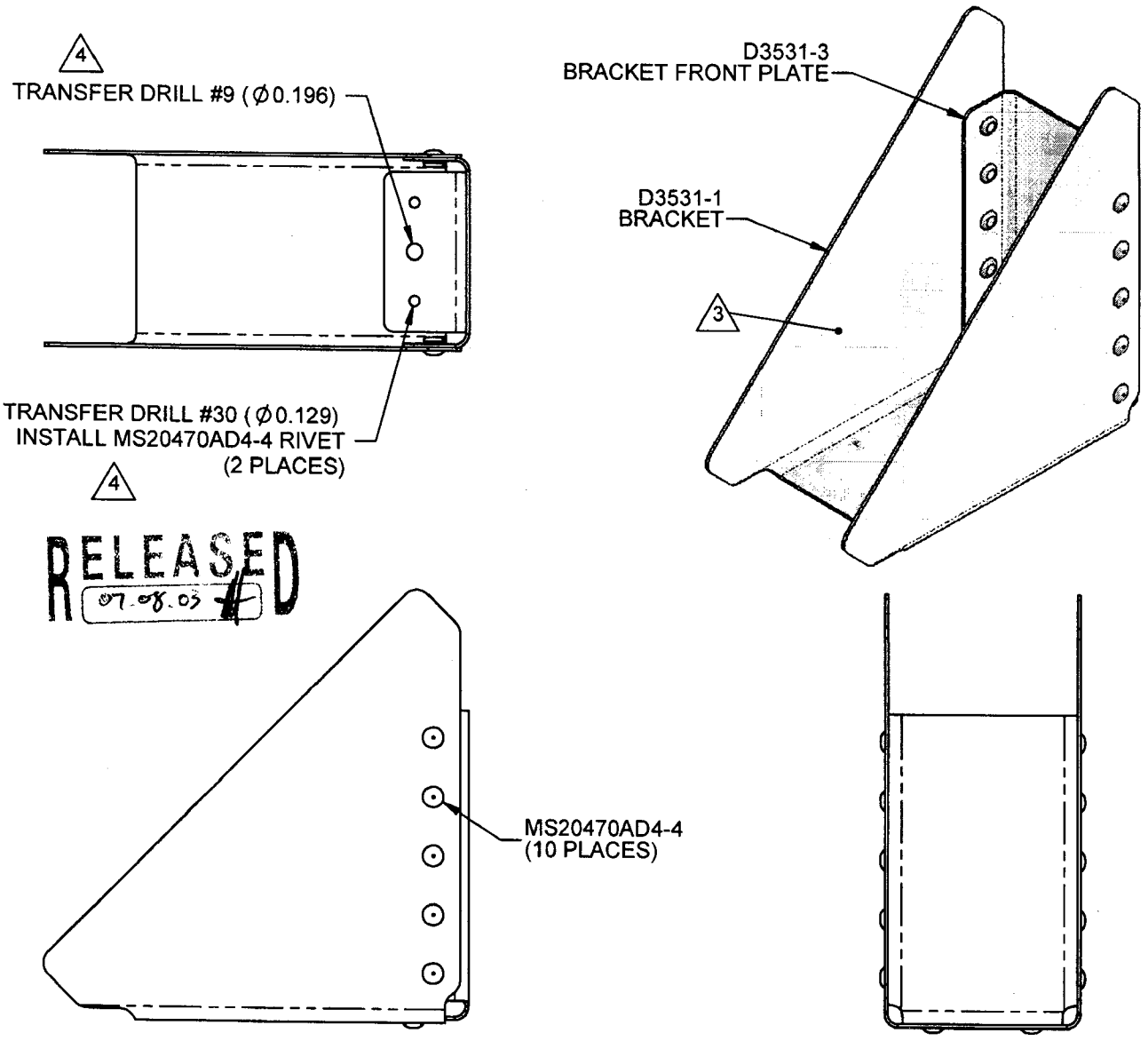
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	2		V BC2	
3.72	+/-0.030	3.727	2		V	
0.37	+/-0.030	.368	2		V	
2.840	+/-0.010	2.839	2		V	
0.88	+/-0.030	.883	2		V	
3.50	+/-0.030	3.506	2		V	
4.67	+/-0.030	4.674	2		V	

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	12-3-8	Date:	12/03/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	

DESIGN	DRAWN BY	DART AEROSPACE LTD
CB	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. A
LE		D3531 SHEET 1 OF 3
DATE		TITLE SCALE
07.06.19		BRACKET ASSEMBLY 1:2

REV	DATE	DESCRIPTION
A	07.06.19	NEW ISSUE



RELEASED
07.08.03

D3531-041 BRACKET ASSEMBLY

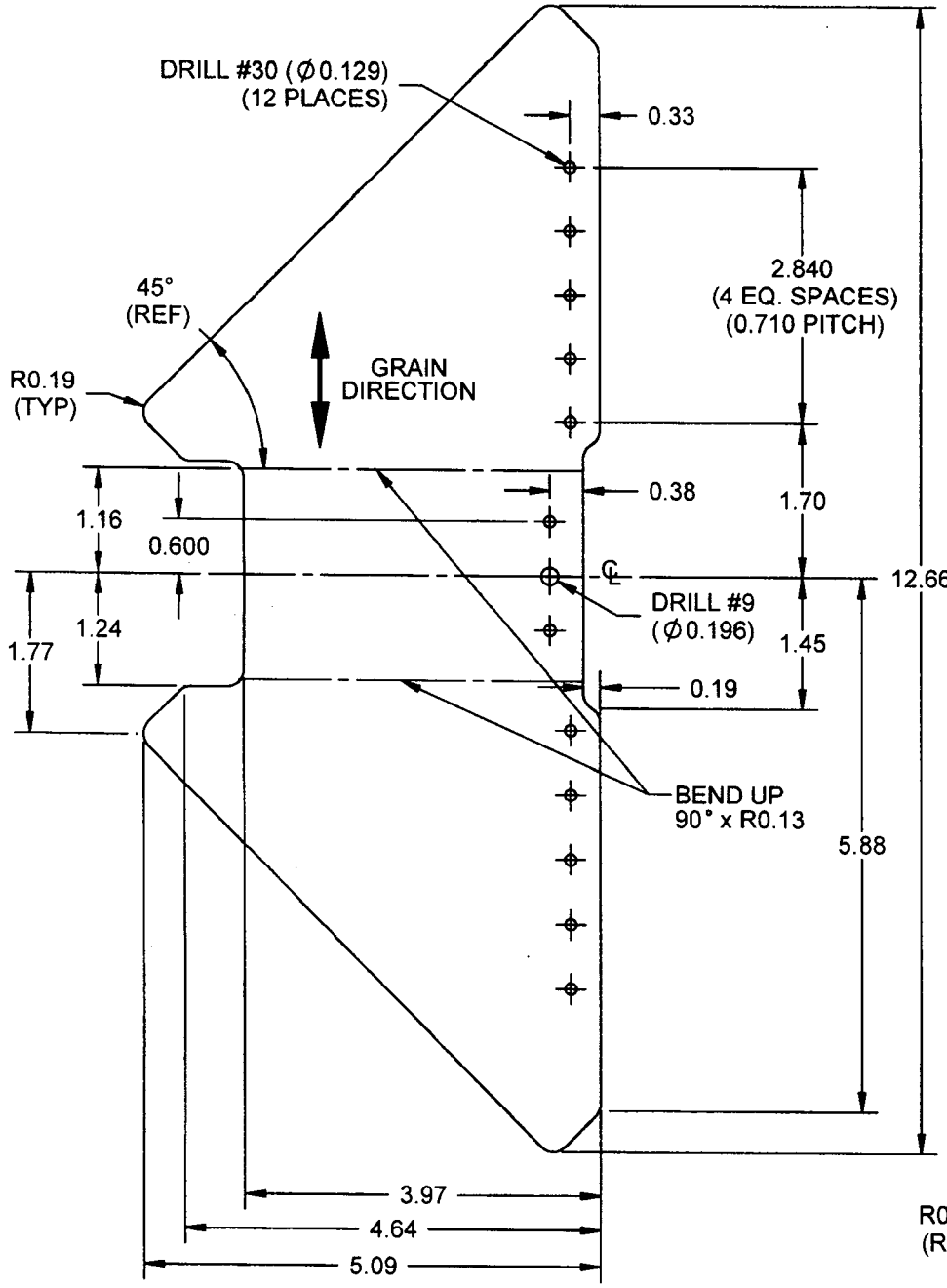
NOTES:

1) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3 ALL PARTS
2) ASSEMBLE PER DART QSI 003
3) IDENTIFY WITH DART P/N "D3531-041" USING WHITE MARKER ON INSIDE OF BRACKET ASSEMBLY, WHERE INDICATED
4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET THROUGH D3531-3 BRACKET FRONT PLATE BEFORE FINISHING

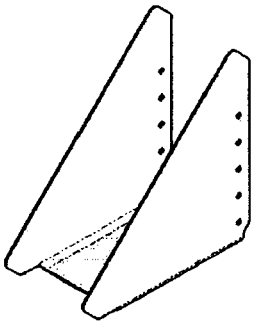
PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

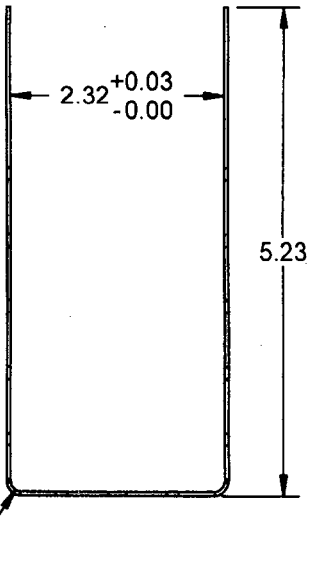
DESIGN	DRAWN BY	DART AEROSPACE LTD
CB	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. A
LE		D3531 SHEET 2 OF 3
DATE		TITLE SCALE
07.06.19		BRACKET ASSEMBLY 1:2



D3531-1F FLAT PATTERN



RELEASED
07.08.03

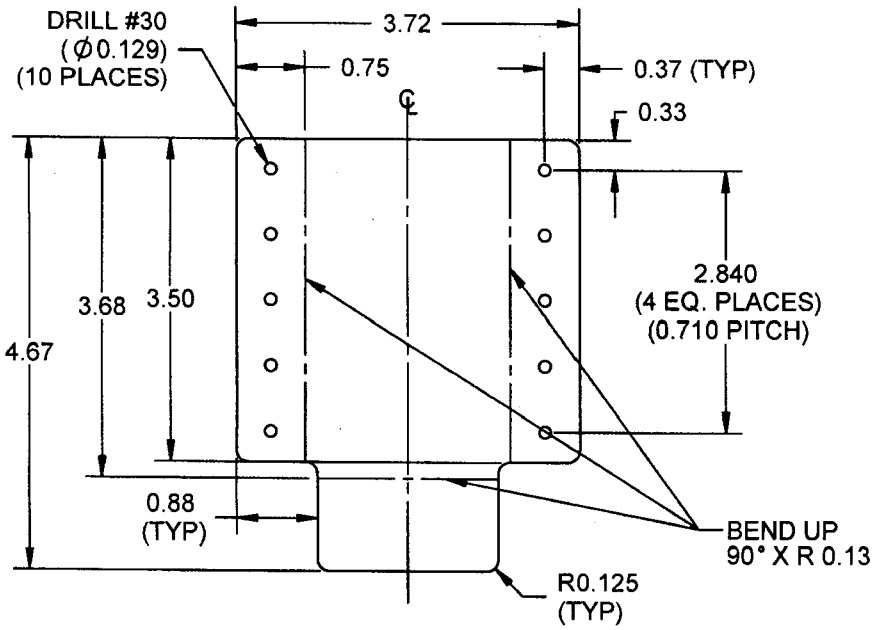


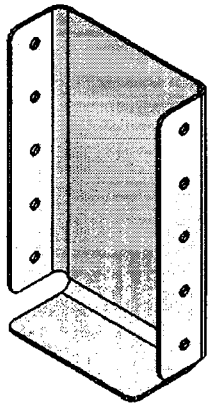
D3531-1 BRACKET

NOTES:
1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS TO 0.010 MAX
6) PART IS SYMMETRIC ABOUT ℄

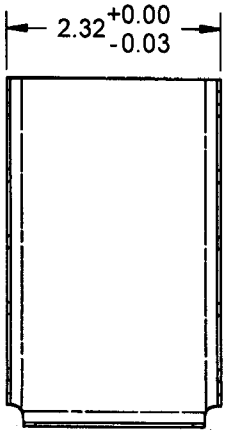
DESIGN	DRAWN BY	DART AEROSPACE LTD
CB	CB	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. REV. A
LE		D3531 SHEET 3 OF 3
DATE		TITLE SCALE
07.06.19		BRACKET ASSEMBLY 1:2

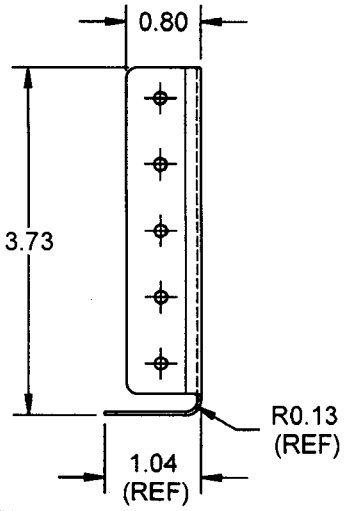
RELEASED
07.08.03





D3531-3F FLAT PATTERN





D3531-3 BRACKET FRONT PLATE

NOTES:
1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS TO 0.010 MAX
6) PART IS SYMMETRIC ABOUT ℄